

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029680**Date Inspected:** 11-Jun-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** USA Hoist**Location:** Crest Hill, IL

CWI Name:	Robert Zimny		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No N/A
Weld Procedures Followed:	Yes	No N/A
Verified Joint Fit-up:	Yes	No N/A
Approved WPS:	Yes	No N/A
Delayed / Cancelled:	Yes	No N/A
Component:	SAS Tower Elevator	

Bridge No: 34-0006**Summary of Items Observed:**

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at USA Hoist, Crest Hill, IL as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

After completing the 1/4" fillet welds on all sides of 5" long x 3 1/2" wide x 3/8" thick stiffener plate to rear tie-in bracket bent plate (142 pieces), no welding work was done at the shop for the tower elevator today. The next two different types of tower elevator brackets that USA Hoist was supposed to weld were sent back to the shop that did the bending due to not meeting the 90 degree bend that was required. They were 142 pieces of tower tie-in brackets (drawing #914204-18) and 146 pieces of front tie-in brackets (drawing #914204-14) that will be fillet welded with stiffener at the middle of each bracket. USA Hoist is hoping that these materials will be backed in few days' time.

This QA performed random initial verification on the 1/4" fillet weld that was just completed on 142 pieces of rear tie-in brackets. The surface profile of the fillet welds on the brackets was noted and the size of the fillet weld was also measured. Generally, all the brackets that were verified deemed to conform to the requirements of the project per AWS D1.1 code. This initial verification was made while waiting for USA Hoist Quality Control (QC) Inspector Robert Zimny to perform his inspection.

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At USA Hoist fabrication shop, 142 pieces of rear tie-in brackets for tower elevator were completely welded with 1/4" fillet weld on all sides of the stiffener plate to the bent plate.



At USA Hoist fabrication shop, 142 pieces of rear tie-in brackets for tower elevator were completely welded with 1/4" fillet weld on all sides of the stiffener plate to the bent plate.



Summary of Conversations:

No significant conversation occurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas 916-764-6027, who represents the Office of Structural Materials for your project.

Inspected By: Lizardo, Joselito

Quality Assurance Inspector

Reviewed By: Foerder, Mike

QA Reviewer